



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE703A94-1130-01-23

Job Sheet 187708



Part No: RBE703A94-1130-01-23

Job Qty: 5 ea

Part Name: Deflection Clip Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/12/18

Job Tracking No:

Due Date: 1/10/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE703A94-1130-01 Rev K IPP Rev.A 17.08.09 New issue DP Verify DD/IPP Rev B 17.11.30 DWG Rev B DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	1/10/19	1/10/19	0.00	0.00	Start Up Small Fab-2		MCC
110	Small Fab	5 pcs	1/10/19	1/10/19	0.00	5.00	Small Fab-3		MCC DAS
120	QC	5 pcs	1/10/19	1/10/19	0.00	0.00	QC5		DAS 38
130	Packaging	5 pcs	1/10/19	1/10/19	0.00	0.00	Packaging3-1		28 9-89
140	QC21-SA	5 Ea	1/10/19	1/10/19	0.00	0.00	QC21		9-89

Part Op 110 - 1-Assemble as per DWG. Sheet 9. 2-Apply Loctite to mating surfaces of item -33 and -27 -Loctite 263
Descriptions: B M138404 Exp.: 4/20 ***Item -33 should not protrude past the surface of item -27***

DAS
21
9-89

JAN 0 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90353A214	Pan Head Machine Screw M4 x 0.7mm x 12mm	10 Ea (2 ea)	90-Start up Operation	M138414-6
91595A155	Dowel Pin 4mm x 12mm	10 Ea (2 ea)	90-Start up Operation	5091269
98296A882	Slotted Spring Pin Ø1/8" X 7/8"	5 Ea (1 ea)	90-Start up Operation	M138414-34
98338A022	Cotter Pin Ø3/64" X 1/2"	10 Ea (2 ea)	90-Start up Operation	M138414-35
RBE703A94-1130-01-25	Tab Adjuster Handle	5 Ea (1 ea)	90-Start up Operation	5126672
RBE703A94-1130-01-27	Tab Adjuster Body	5 Ea (1 ea)	90-Start up Operation	5128330
RBE703A94-1130-01-29	Tab Adjuster Clamp	5 Ea (1 ea)	90-Start up Operation	5126936
RBE703A94-1130-01-31	Tab Adjuster Gauge Plate	5 Ea (1 ea)	90-Start up Operation	5127281
RBE703A94-1130-01-33	Adjuster	10 Ea (2 ea)	90-Start up Operation	5127539
6NF45/A	Knurled Nut	10 Ea (2 ea)	90-Start up Operation	514540

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	6NF45/A	10	0 on order	0
	90353A214	10	32	0
	91595A155	10	83	0
	98296A882	5	218	0
	98338A022	10	32	0
	RBE703A94-1130-01-25	5	5	0
	RBE703A94-1130-01-27	5	5	0
	RBE703A94-1130-01-29	5	5	0
	RBE703A94-1130-01-31	5	5	0
	RBE703A94-1130-01-33	10	20	0

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Part Specifications

Specifications could not be found.

Plex 12/12/18 8:01 AM Dart.lajeunesse.marie



Container No: S142166



Part: RBE703A94-1130-01-23

Job No: 187708

Serial No/Batch: S142166

Revision: k

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/07/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

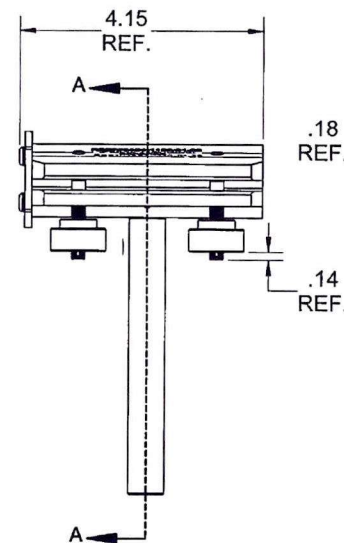
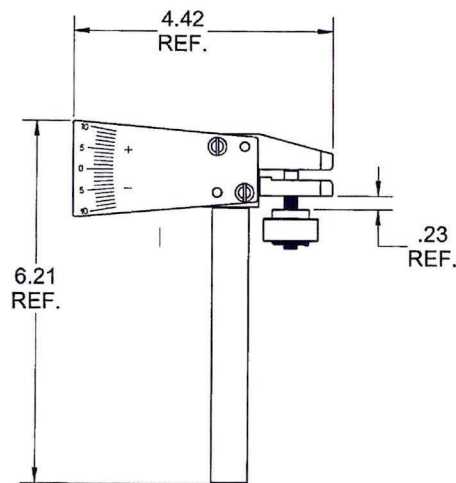
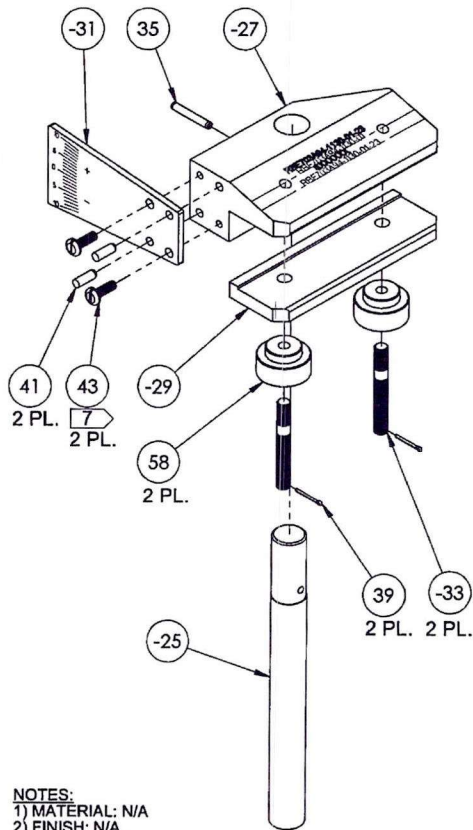
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

ITEM #	QTY	PART #	TITLE	PG
-25	1	RBE703A94-1130-01-25	TAB ADJUSTER HANDLE	10
-27	1	RBE703A94-1130-01-27	TAB ADJUSTER BODY	11
-29	1	RBE703A94-1130-01-29	TAB ADJUSTER CLAMP	12
-31	1	RBE703A94-1130-01-31	TAB ADJUSTER GAUGE PLATE	13
-33	2	RBE703A94-1130-01-33	ADJUSTER	14
35	1	McMaster#98296A882	SPRING PIN Ø1/8 X 7/8	-
39	2	McMaster#98338A022	COTTER PIN Ø3/64 X 1/2	-
41	2	McMaster#91595A155	DOWEL PIN 4mm X 12mm	-
43	2	McMaster#90353A214	PAN HEAD M4 x 0.7 x 12mm	-
58	2	J.W. WINCO #6NF46A	KNURLED NUT M6 X 1.0 DIN 6303 TYPE A	-

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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 187708M5
18-12-12



SECTION A-A

RBE703A94-1130-01-23 DEFLECTION CLIP ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) HEAT TREAT: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) APPLY LOCTITE 263 OR EQUI.

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE: DEFLECTION CLIP ASSY	
DWG NO: RBE703A94-1130-01-23	REV K
DESIGN BY: VM 8/28/2017	XXX ± .005 FRACTIONS & 1/8
DRAWN BY: VM 11/24/2017	XX ± .01 ANGLES ± 5°
CHECKED: VM 11/30/2017	X ± .1 SURFACES ± 12°
MFG. APPR: JDP 11/30/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
APPROVED: VM 11/30/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE: 11/24/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE: NTS	WEIGHT: N/A
SHEET 9 OF 17	
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